

**Work Order ID 68162**

Thursday, April 07, 2011 11:12:12 AM



Page 1

Item ID: D4274-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Plate, Aft Support

Start Date: 4/7/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 4/14/2011 Req'd Qty: 6.00

Customer:

Reference:

Approvals:

Process Plan:

Date: 11-04-7

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4274	B								

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev:

Prog Rev:

304 .128

2-Deburr if necessary

B11-4-7



110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B11-4-7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Page 2

Item ID: D4274-3

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Start Date: 4/7/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 4/14/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Subtotal

Quality Control

(46)

130

Identify as per dwg &amp; Stock Location: 139B

0.00



Packaging

Memo

0.00

Packaging

Pm/4/11 (6)

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/4/11

MF

11-04-01

**Dart Aerospace Ltd**

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
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**NOTE:** Date & initial all entries

# Picklist Print

Thursday, April 07, 2011 11:12:17 AM

Page 1

Work Order ID: 68162



Parent Item: D4274-3



Parent Item Name: Plate, Aft Support



Start Date: 4/7/2011

Required Date: 4/14/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP rev:A 10.11.18 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S11GA  304/316 0.125 Sheet		Purchased	No			100	sf	23.0000	0.357 	2.254737 1811-4-7			

Location

Loc Qty

Loc Code

MAT020

23

116623

23

116623

6

**Dart Aerospace Ltd**

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	68162
<b>Description: Plate, Aft Support</b>		<b>Part Number:</b>	D4274-3
<b>Inspection Dwg: D4274</b>	<b>Rev: B</b>	<b>Page 1 of 2</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.129	+0.005/-0.001	.130	X			
Ø0.191	+0.005/-0.001	.191	X			
Ø0.250	+0.006/-0.001	.250	X			
Ø0.53	+0.008/-0.001	.529	X			
4.25	+/-0.030	4.255	✓			
1.02	+/-0.030	1.02	X			
3.83	+/-0.030	3.826	X			
0.310	+/-0.010	.312	X			
0.750	+/-0.010	.745	X			
7.05	+/-0.030	7.05	X			
0.92	+/-0.030	.926	✓			
5.91	+/-0.030	5.910	X			
8.95	+/-0.030	8.959	X			
2.80	+/-0.030	2.798	X			
1.05	+/-0.030	1.055	X			
0.60	+/-0.030	.603	X			
1.20	+/-0.030	1.207	X			
1.10	+/-0.030	1.092	✓			
0.75	+/-0.030	.752	X			
3.000	+/-0.010	3.002	✓			
1.500	+/-0.010	1.501	X			
2.300	+/-0.010	2.303	✓			
1.367	+/-0.010	1.367	X			
0.36	+/-0.030	.36	X			
0.792	+/-0.010	.792	X			
0.672	+/-0.010	.672	X			
0.464	+/-0.010	.464	✓			
0.70	+/-0.030	.70	✓			
3.000	+/-0.010	3.004	X			
0.750	+/-0.010	.752	X			
0.68	+/-0.030	.683	X			

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**NOTE:** Date & initial all entries



11-01-07 1.12

[illegible]

Eval:	
Date:	
by	Appr
	

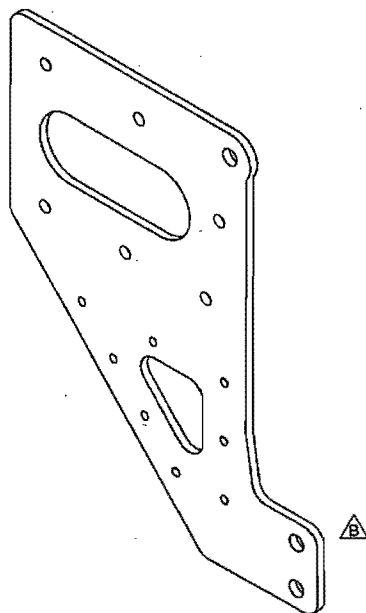
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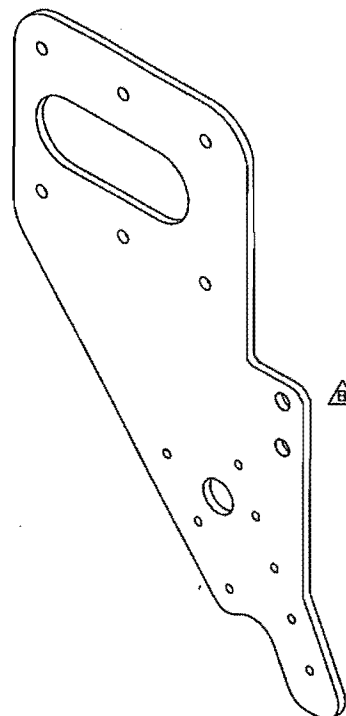
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**D4274-1 PLATE, FWD SUPPORT**



**D4274-3 PLATE, AFT SUPPORT**

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 68142

BS11-04-7

**RELEASED**  
R 2010-08-06  
JMP

B	D4274-1, D4274-3 PLATES LENGTH INCREASED BY 0.25"; HOLES OPENED TO 0.25" FOR AN4 BOLTS	SC	10.12.02
A	NEW ISSUE	SC	10.11.30
REV.	DESCRIPTION	BY	DATE
DESIGN	JPH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D4274	SHEET 1 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	PLATES, BASKET SUPPORT	NTS
DATE	10.12.02	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRELIMINARY AND CONFIDENTIAL. IT IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR FOR THE CONSTRUCTION OF ANY OTHER PRODUCT WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

**Dart Aerospace Ltd**

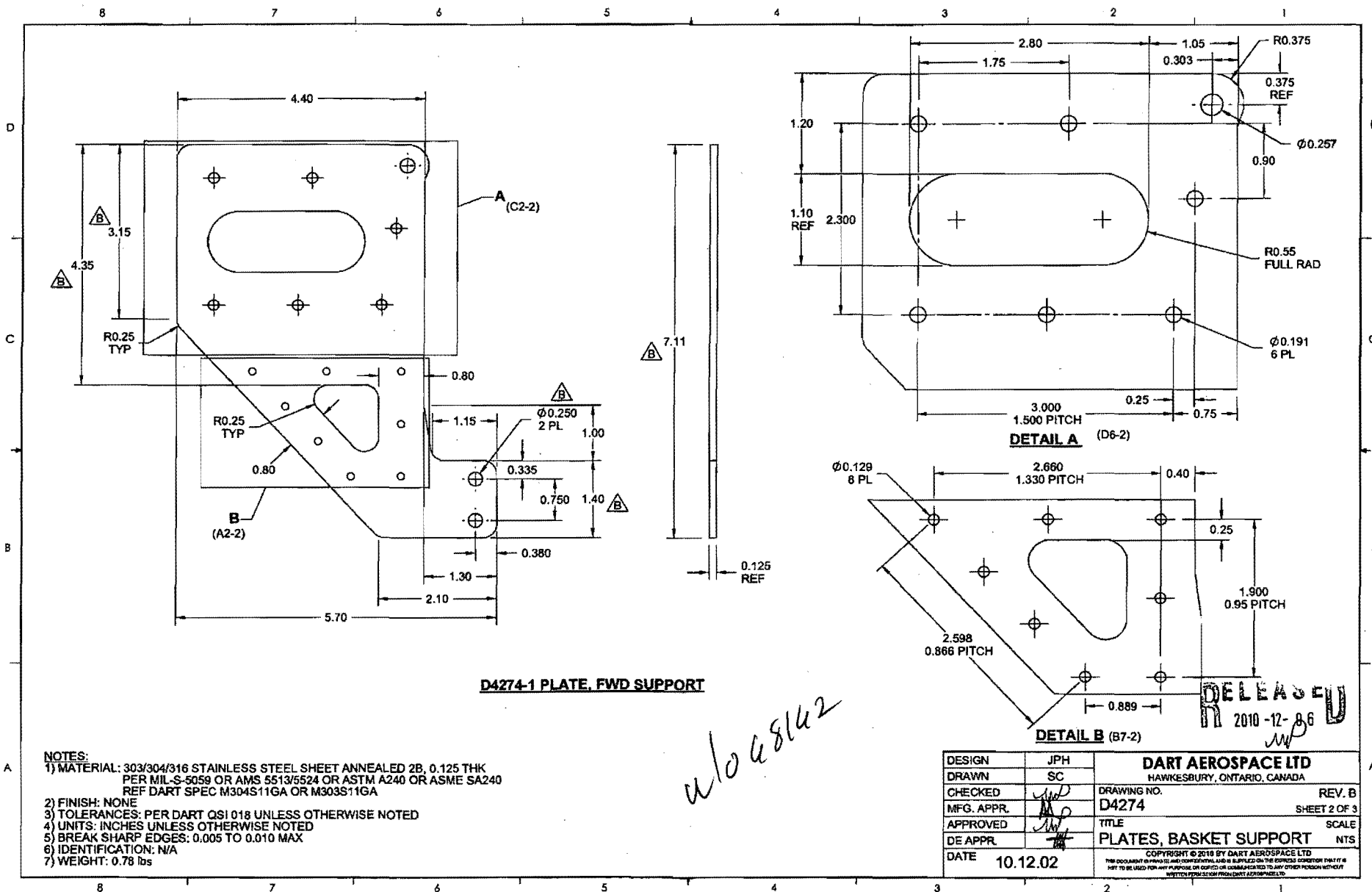
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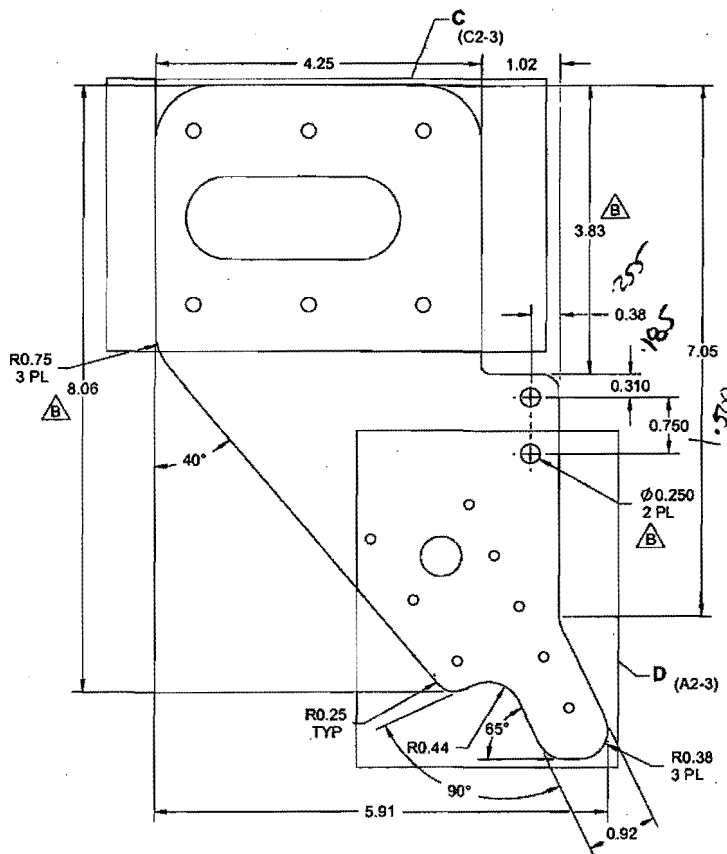
**Dart Aerospace Ltd**

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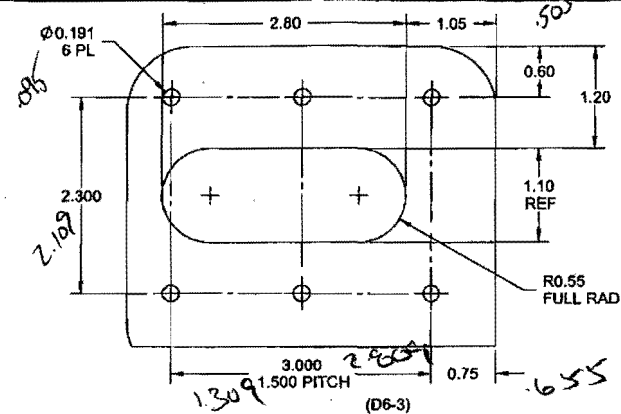
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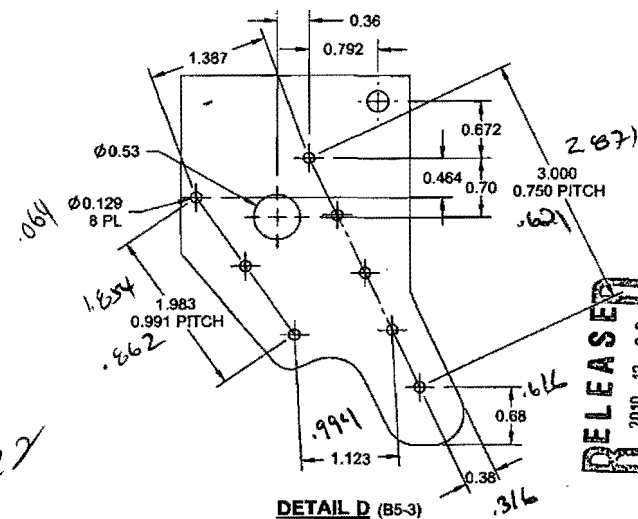
**D4274-3 PLATE, AFT SUPPORT**

**NOTES:**

- 1) MATERIAL: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.125 THK  
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240  
REF DART SPEC M304S11GA OR M303S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.97 lbs



**DETAIL C**



**DETAIL D (B5-3)**

DESIGN	JPH	<b>DART AEROSPACE LTD</b>	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	WMS	DRAWING NO.	REV. B
MFG. APPR.	WMS	<b>D4274</b>	SHEET 3 OF 3
APPROVED	WMS	TITLE	SCALE
DE APPR.	WMS	<b>PLATES, BASKET SUPPORT</b>	NTS
DATE	10.12.02	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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RELEASED  
2010-12-06  
JPH

*WMS 081102*

**Dart Aerospace Ltd**

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